

Work Order ID 83418

April-18-12 8:10:26 AM

83418

Page 1

Item ID: D2939-2

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle RH In, 206

Start Date: 18/04/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 02/05/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MLJDate: 12/04/18 Tooling:Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2939

Rev C

100

0.00

100

HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

FK 12/07/08

10

HAAS CNC vertical machine #1

Program part number and batch number.1-Inspect part number and batch number are programmed correctly.2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per

110

0.00

110

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

FK 12/07/08

10

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

120

QC1- Inspect dimensions to dimension sheet

0.00

120

QC

Memo

0.00

FK 12/07/08

10

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83418

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Page 2

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N900040100

Setup Start

NS1

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Start Date: 18/04/2012 Start Qty: 6.00

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Required Date: 02/05/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00							
			OK 12/07/09			10	0		
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							
			10 2/12-7-10						
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo	0.00 0.00							
	START TIME: 2-30 FINISH TIME: 3-00		10 X 0						mf 12/07/10

W121841

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 83418***83418***

Page 3

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Accept

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Revision ID:

Stop ***NS2***

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Start Date: 18/04/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 02/05/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: Date: Tooling:

Date:

Run Start ***NR1***

QC: Date: SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

10x 4 11/02/10

170

Identify as per dwg & Stock Location: 428A 0.00***170***

Packaging

Memo

0.00

Packaging

102 12-7-11 Syf

180

QC21- Final Inspection - Work Order Release 0.00

180

QC

Memo

0.00

Quality Control

CK 12/7/12

11/20/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-18-12 8:10:30 AM

Page 1

Work Order ID: 83418

83418

Parent Item: D2939-2

D2939-2

Parent Item Name: Saddle RH In, 206

Start Date: 18/04/2012

Required Date: 02/05/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: B 00.06.26 New DWG rev (mpp 2069)EC
IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001		Manufactured	No			100	Each	57.0000	1	6			
D6101-001									**	10		12/07/06	
Saddle Billet													

Location

Loc Qty

Loc Code

MAT040

3

69677

2

76836

1

MAT041

54

80764

4

→ 81923

50

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 83418
Description: 206 Saddle, Inboard, Right side		Part Number: D2939-2
Inspection Dwg: D2939 Rev: C DSK: Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ **First Article**
☐ **Prototype**

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140						
B	0.100	0.140						
C	0.100	0.140						
D	0.210	0.230						
E	1.245	1.255						
F	1.245	1.255						
G	2.495	2.505						
H	0.510	0.515						
I	1.572	1.582						
J	2.495	2.505						
K	0.257	0.262						
L	0.312	0.317						
M	0.235	0.240						
N	0.100	0.140						
O	0.540	0.560						
P	0.490	0.510						
Q	3.715	3.725						
R	2.720	2.760						
S	0.240	0.270						
T	0.100	0.180						
U	1.625	1.635						
V	1.362	1.372						
W	0.316	0.321						
X	1.250	1.270						
Y	1.565	1.585						
Z	0.178	0.198						
AA								
AB								
AC								
AD								
Accept/Reject								

Measured by:		Date:	
Audited by:		Date:	
Prototype Approval:	N/A	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	
D	07.11.23	DT8695 A/B removed	KJ/EC/DD	

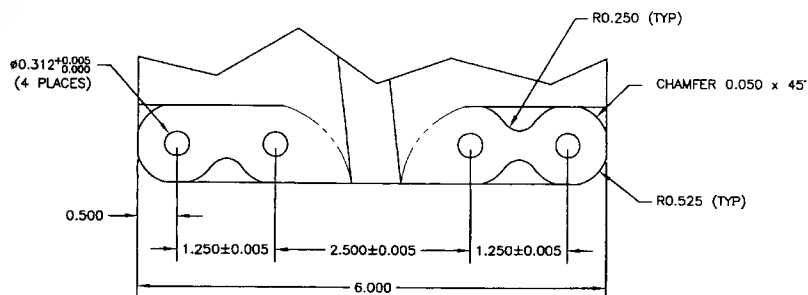
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

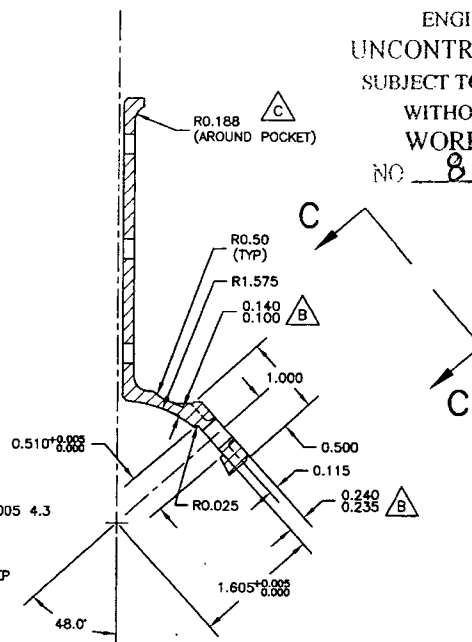
NOTE: Date & initial all entries



VIEW C-C

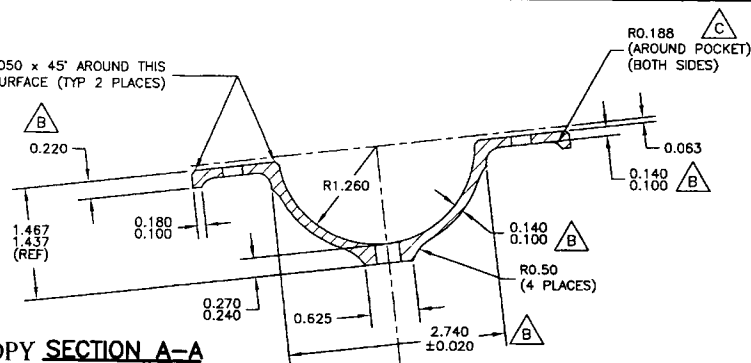
D2939-1 LH SADDLE (SHOWN)
D2939-2 RH SADDLE (OPPOSITE)

- NOTES:**
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
 (MAKE FROM D6101-001 SADDLE BILLET, 7075)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE INCHES
 - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



SECTION B-B

CHAMFER 0.050 x 45° AROUND THIS SURFACE (TYP 2 PLACES)

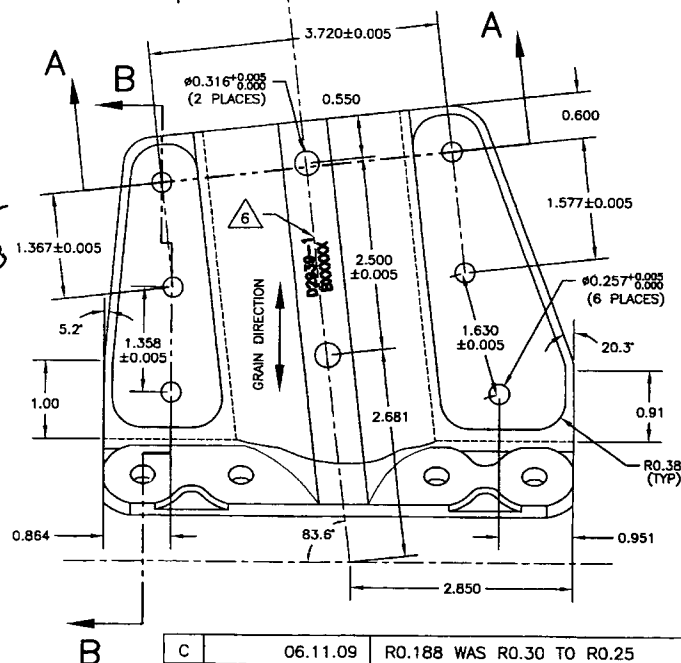


SHOP COPY SECTION A-A

RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER

NO 83418

MLJ
 12/04/18



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED DEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC.
CHECKED	APPROVED	DART DART AEROSPACE USA, INC.
DATE	TITLE	DART DART AEROSPACE USA, INC.
06.11.09	SADDLE INSIDE	DART DART AEROSPACE USA, INC.

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DART DART AEROSPACE USA, INC.

DRAWING NO. D2939

SHEET 1 OF 1

SCALE 2:3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	5472
Description: 206 Saddle, Inboard, Right side		Part Number:	D2939-2
Inspection Dwg: D2939 Rev: C DSK: Rev:		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.103	.108	.108	.108	.108
B	0.100	0.140		.103	.108	.108	.108	.107
C	0.100	0.140		.119	.119	.116	.116	.116
D	0.210	0.230		.224	.224	.224	.224	.223
E	1.245	1.255	1.250	1.250	1.250	1.250	1.250	1.250
F	1.245	1.255		1.250	1.250	1.250	1.250	1.250
G	2.495	2.505		2.500	2.500	2.500	2.500	2.500
H	0.510	0.515		.512	.512	.512	.512	.512
I	1.572	1.582		1.577	1.577	1.577	1.577	1.577
J	2.495	2.505		2.500	2.500	2.500	2.500	2.500
K	0.257	0.262		.258	.258	.258	.258	.258
L	0.312	0.317		.314	.314	.314	.314	.314
M	0.235	0.240		.236	.236	.236	.236	.236
N	0.100	0.140		.120	.121	.119	.120	.120
O	0.540	0.560		.550	.550	.550	.550	.550
P	0.490	0.510		.500	.500	.500	.500	.497
Q	3.715	3.725		3.720	3.720	3.720	3.720	3.720
R	2.720	2.760		2.740	2.740	2.740	2.740	2.740
S	0.240	0.270		.250	.252	.250	.250	.251
T	0.100	0.180		.135	.135	.135	.135	.135
U	1.625	1.635		1.630	1.630	1.630	1.630	1.630
V	1.362	1.372		1.367	1.367	1.367	1.367	1.367
W	0.316	0.321		.317	.317	.317	.317	.317
X	1.250	1.270		1.2615	1.261	1.260	1.2615	1.261
Y	1.565	1.585		1.574	1.576	1.574	1.575	1.576
Z	0.178	0.198		.188	.188	.188	.188	.188
AA								
AB								
AC								
AD								
Accept/Reject								

Measured by: F.K.	Date: 12/07/08
Audited by: <i>amf</i>	Date: 12/07/09
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	
D	07.11.23	DT8695 A/B removed	KJ/EC/DD	

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DART AEROSPACE LTD		Work Order: 25172
Description: 206 Saddle, Inboard, Right side		Part Number: D2939-2
Inspection Dwg: D2939	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6	7	8	9	10
A	0.100	0.140		.108	.108	.108	.108	.108
B	0.100	0.140		.108	.108	.108	.108	.108
C	0.100	0.140		.119	.120	.120	.120	.120
D	0.210	0.230		.223	.223	.223	.223	.223
E	1.245	1.255		1.250	1.250	1.250	1.250	1.250
F	1.245	1.255		1.250	1.250	1.250	1.250	1.250
G	2.495	2.505		2.500	2.500	2.500	2.500	2.500
H	0.510	0.515		.512	.512	.512	.512	.512
I	1.572	1.582		1.577	1.577	1.577	1.577	1.577
J	2.495	2.505		2.500	2.500	2.500	2.500	2.500
K	0.257	0.262		.258	.258	.258	.258	.258
L	0.312	0.317		.314	.314	.314	.314	.314
M	0.235	0.240		.236	.236	.236	.236	.236
N	0.100	0.140		.120	.120	.120	.120	.120
O	0.540	0.560		.551	.550	.550	.550	.550
P	0.498	0.510		.497	.498	.498	.497	.497
Q	3.715	3.725		3.720	3.720	3.720	3.720	3.720
R	2.720	2.760		2.740	2.740	2.740	2.740	2.740
S	0.240	0.270		.250	.250	.250	.250	.251
T	0.100	0.180		.135	.135	.135	.135	.135
U	1.625	1.635		1.630	1.630	1.630	1.630	1.630
V	1.362	1.372		1.367	1.367	1.367	1.367	1.367
W	0.316	0.321		.317	.317	.317	.317	.317
X	1.250	1.270		1.261	1.260	1.261	1.260	1.261
Y	1.565	1.585		1.576	1.576	1.576	1.575	1.576
Z	0.178	0.198		.188	.188	.188	.188	.188
AA								
AB								
AC								
AD								
Accept/Reject								

Measured by: <i>FK</i>	Date: 12/07/08
Audited by: <i>AK</i>	Date: 12/07/09
Prototype Approval: N/A	Date: N/A

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